

Date: Wednesday, 2/20/2008 4:23:40 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 FLOAT SKIDTUBE
Job Number : 37545	
Estimate Number : 11437	
P.O. Number :	Part Number : D3391015
This Issue : 2/20/2008 S.O. No. :	Drawing Number : D3391 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : G
Previous Run : 33476	Material :
Written By :	Due Date : 3/15/2008 Qty: 1 Um: Each
Checked & Approved By : <u>080221</u>	
Comment : est rev A 05.12.13 New issue EC	
est rev B 06.02.09 Dwg @ revD EC	
est rev C 07.03.13 dwg @ revF ec	
est rev D 07.10.31 ecn 1053P EC	
Est Rev:E ECN 1056 07-11-13 DD verified by: EG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
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Comment: Qty.: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D6014-090	Extrusion	<u>32309</u>
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Identify as D3391-3

20 08/03/06

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: G

J.F. 08/03/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/03/09

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: G

2-Deburr

J.L. 08/07/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:23:40 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37545

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/07/31

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.P 08/08/01

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 8-8-5

8.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391

DP 8-8-5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/05 (X)

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8808 (ALL HOLES)

3-Drill and c' sink wearshoe holes as per Dwg D3391

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391  
Deburr

5- Tranfer holes from D3391-013 for electric step in tube

M 8-8-6

SCRAP

11.0

QC5

INSPECT WORK TO CURRENT STEP


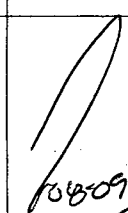
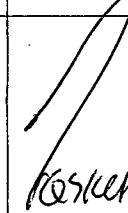

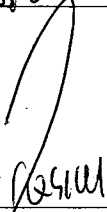
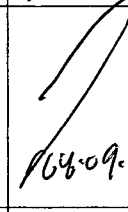
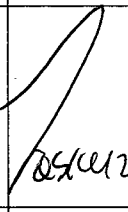
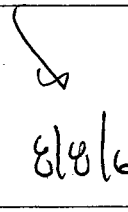


Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/6	# D3	Employee forgot to drill four wear plate holes. In doing this he ended up locating the drill sig for the 2 D3537-1 wear plate holes. He holes to be 7" off. (Lowering)		Scrap and destroy. no replace Qty (2)	H 3-9-9	 10/8/09-09	 10/8/09	 8/8/6
↓	↓	Supple) R.C. employee forgot to correct drilling sequence on how to drill the <del>plate</del> plate holes for the wear plates. Lack of Attention.		* ensure all Landing Gear employees are up to date on how to correctly fabricate Tri-Beam skid tubes.	H 3-9-9	 10/8/09-09	 10/8/09	 8/8/6

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37545

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

13.0

D36704200

SPACER



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

SPACER

Batch: \_\_\_\_\_

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install crossbolt spacers per dwg D3391

A/R Magnabond 6398 batch: \_\_\_\_\_

2- Grind flush

SCURP

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat/White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Batch: \_\_\_\_\_

Dart Aero

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:23:41 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37545

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: \_\_\_\_\_

20.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

Batch: \_\_\_\_\_

21.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: \_\_\_\_\_

22.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: \_\_\_\_\_

23.0

D36721

PHENOLIC WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PHENOLIC WASHER

Batch: \_\_\_\_\_

24.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

INSERT

Batch: \_\_\_\_\_

or equivalent per

QSI 017

25.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

Batch: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37545

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

or equivalent  
per QSI 017

26.0

ALS4428165

Inserts



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Inserts  
Batch: \_\_\_\_\_

27.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
Bolt  
Batch: \_\_\_\_\_

28.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Bolt  
Batch: \_\_\_\_\_

29.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
WASHER  
Batch: \_\_\_\_\_

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
1-Install inserts per dwg D3391  
  
2-Install Aft Cap as per Dwg D3391  
A/R Sikaflex-241/-291 \_\_\_\_\_  
Sikaflex expiry date: \_\_\_\_\_

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 2/20/2008 4:23:41 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 37545

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	37545
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b>	D3391-3
<b>Inspection Dwg:</b> D3391 <b>Rev:</b> G		<b>Page 1 of 1</b>	

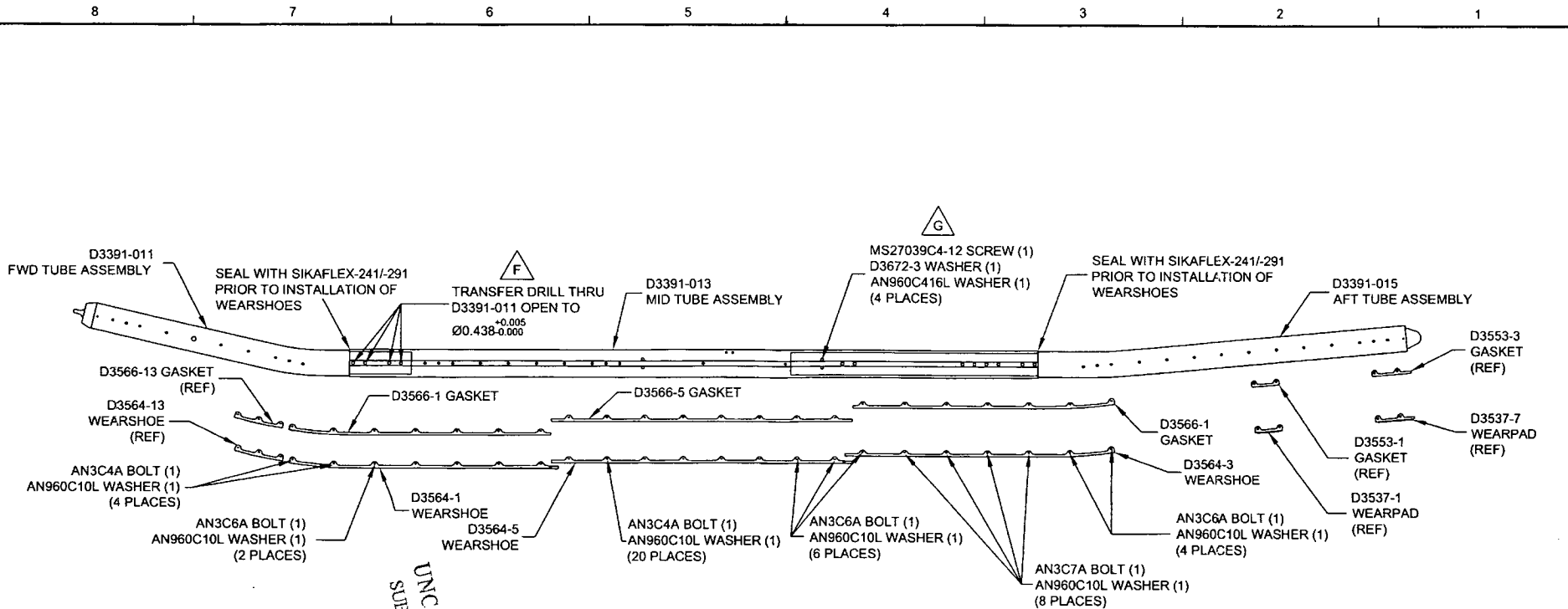
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000"	✓			
3.500	+/-0.010	3.500"	✓			
88.93	+/-0.030	88.930	✓			
44.995	+/-0.030	45.000	✓			
3.200	+/-0.010	3.201	✓			
1.526	+0.000/-0.030	1.517	✓			
0.200	+/-0.010	.200	✓			
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	32.250	✓			
3.300	+/-0.010	3.297	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.688	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.486	✓			

<b>Measured by:</b> J.F./J.L.	<b>Audited by:</b> J.F.	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 08/03/08	<b>Date:</b> 08/08/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue      P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	DD



**D3391-041 ASSEMBLY**

**RELEASED**  
07-11-06

**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

WORK ORDER  
37545  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SUBJECT TO ADVERTISEMENT  
WITHOUT NOTICE

**GENERAL NOTES**

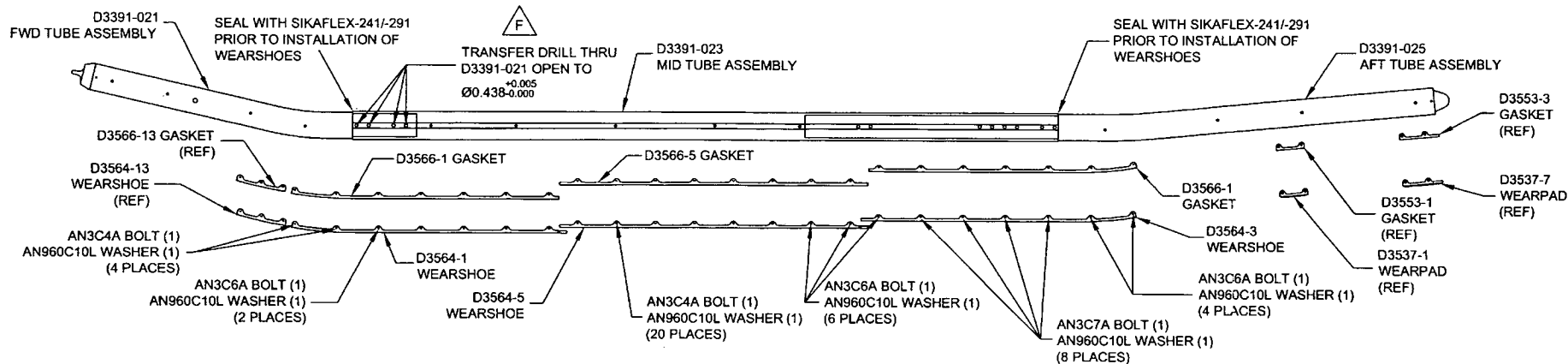
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. REV. G  
D3391 SHEET 1 OF 8  
TITLE SCALE  
412 FLOAT SKIDTUBE NTS

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**D3391-043 ASSEMBLY**

**RELEASED**  
07.11.94

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER

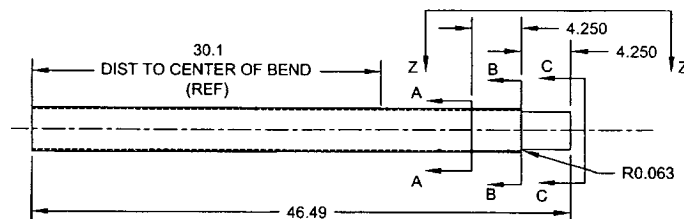
**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

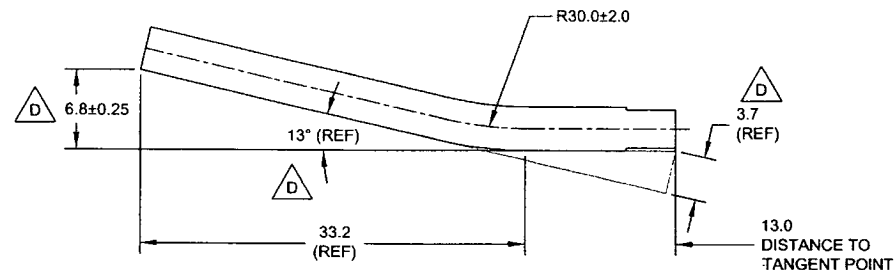
DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC</b>
DRAWN	<i>JJC</i>	PORT HADLOCK, WA
CHECKED	<i>JS</i>	DRAWING NO. D3391
MFG. APPR.	<i>PH</i>	REV. G
APPROVED	<i>PH</i>	SHEET 2 OF 8
DE APPR.	<i>PH</i>	TITLE 412 FLOAT SKIDTUBE
DATE	07.07.31	SCALE NTS

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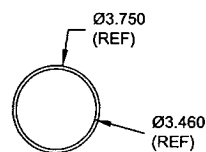
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
WORK ORDER  
10-37545  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE



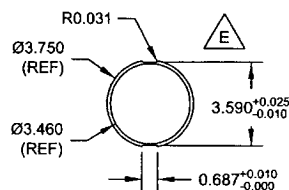
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



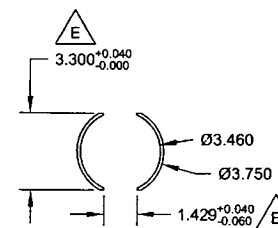
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



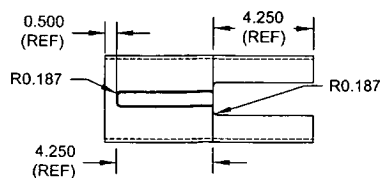
**SECTION A-A**  
(SCALE 1:5)



**SECTION B-B**  
(SCALE 1:5)



**SECTION C-C**  
(SCALE 1:5)



**VIEW Z-Z**  
(SCALE 1:5)

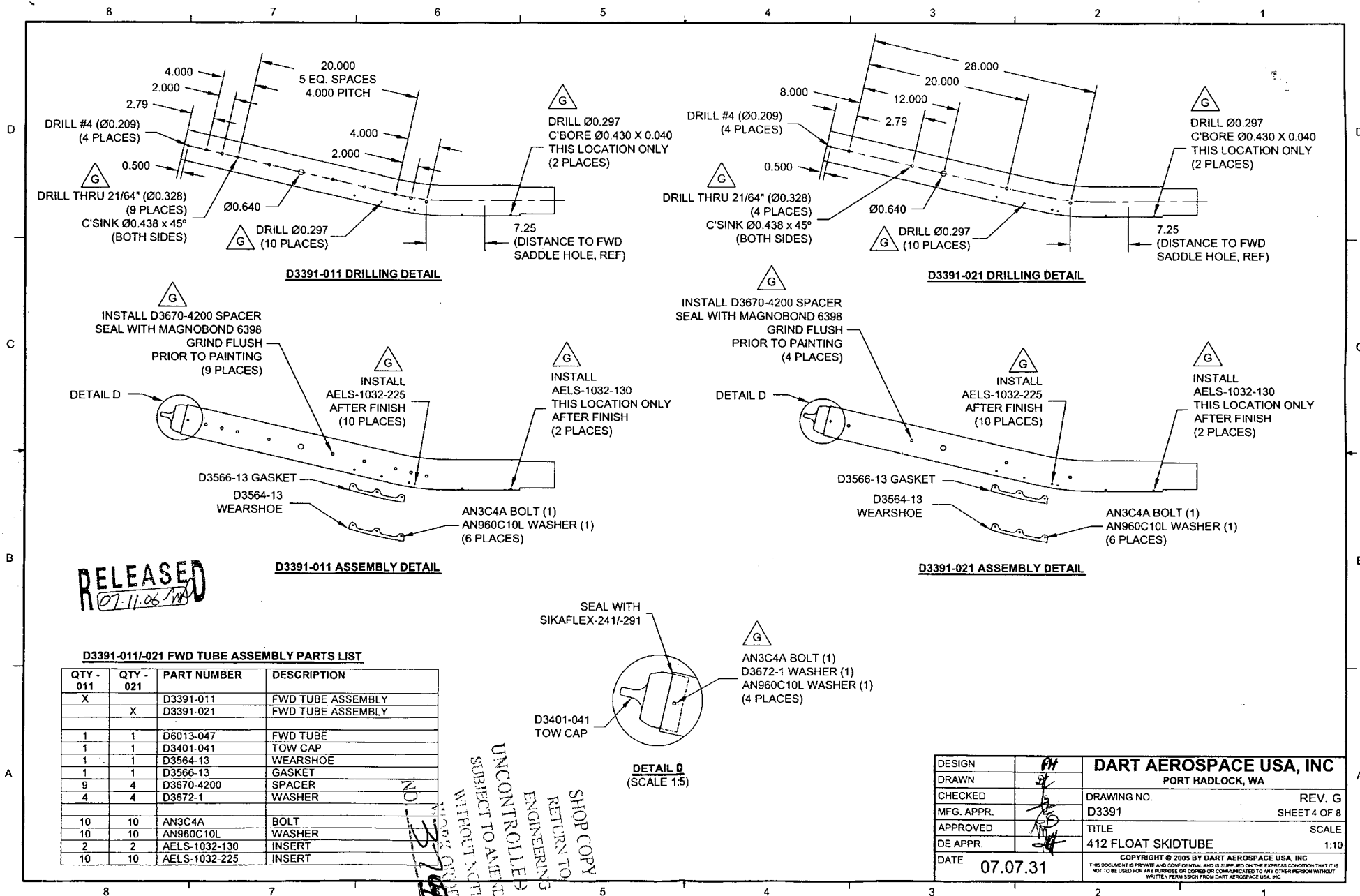
RELEASED  
07-11-26 117

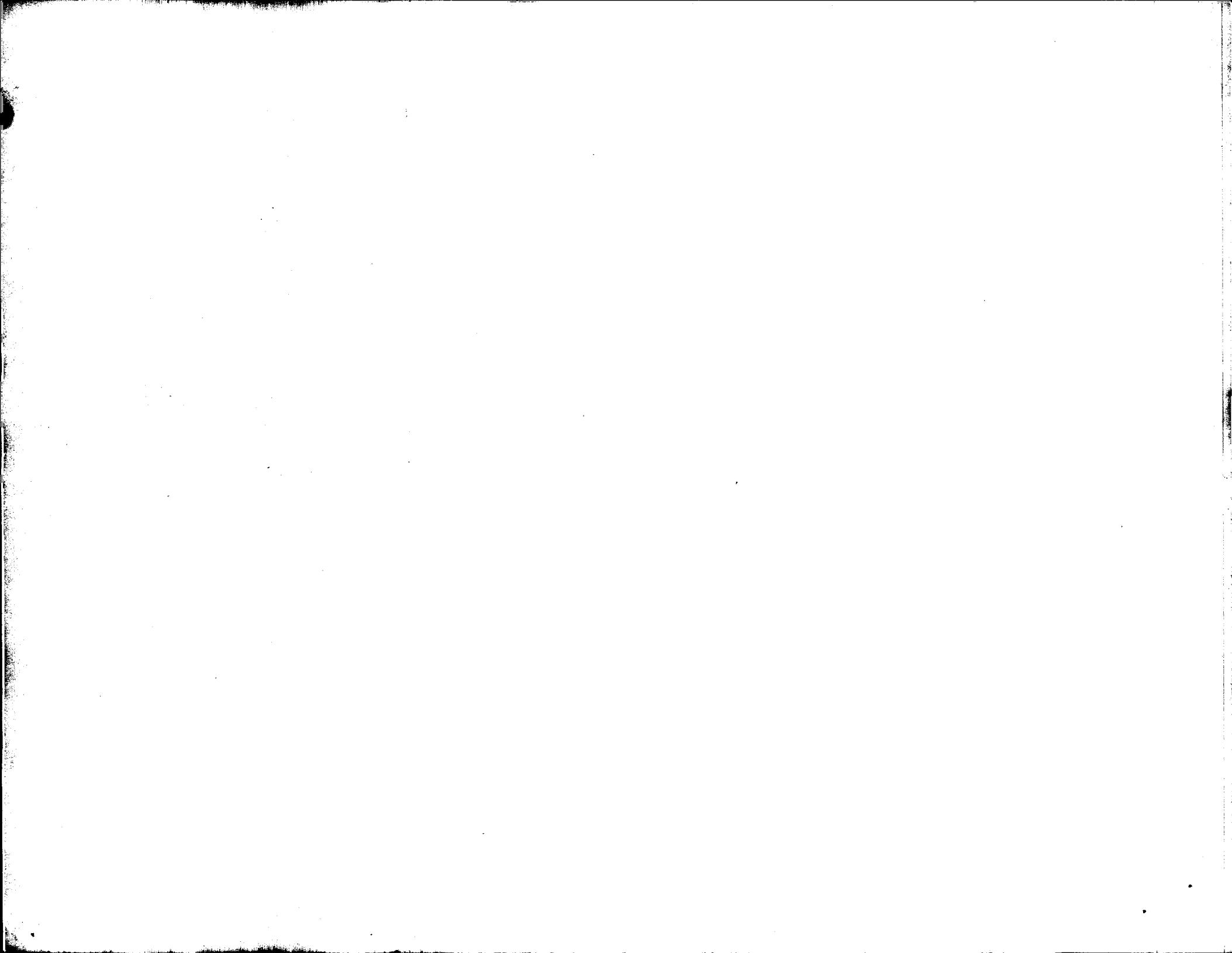
NO. 37545  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY

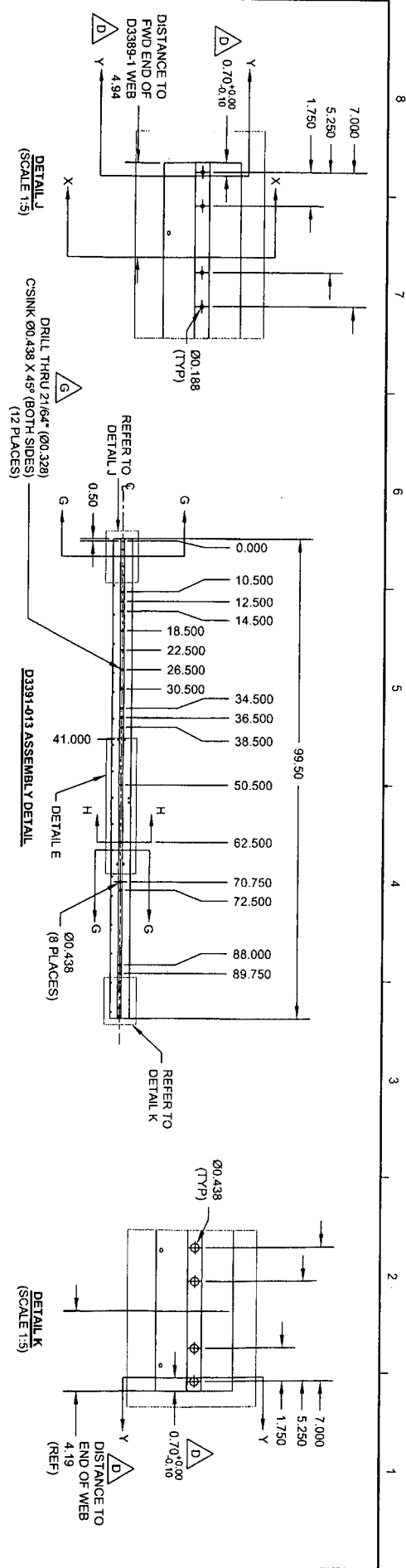
DESIGN		<b>DART AEROSPACE USA, INC</b>
DRAWN		PORT HADLOCK, WA
CHECKED		DRAWING NO. D3391
MFG. APPR.		REV. G SHEET 3 OF 8
APPROVED		TITLE 412 FLOAT SKIDTUBE
DE APPR.		SCALE 1:10
DATE	07.07.31	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC

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SECTION G-G  
(SCALE 1:4)

SECTION H-H (12 PLACES)  
(SCALE 1:4)

SECTION X-X  
(SCALE 1:4)

SECTION Y-Y  
(SCALE 1:4)

SECTION M-M  
(SCALE 1:4)

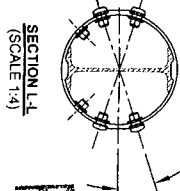
SECTION L-L  
(SCALE 1:4)

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
12	D3681-1	SPACER
4	D3672-1	WASHER
4	D3672-3	WASHER
24	AE1S-1032-130	INSERT
4	AL54-428-165	INSERT
4	AN960C10L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY  
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION  
2) MATERIAL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER OSI 015  
3) WELDING: PER PART OSI 004

DESIGN	44	DART AEROSPACE USA, INC
DRAWN	JP	PORT HADLOCK, WA
CHECKED		
MFG. APPR.		
APPROVED		
DATE	07.07.31	
TITLE	4112 FLOAT SKIDTUBE	REV. G
DE APPR.		SHEET 5 OF 8
SCALE		1:20

WORK ORDER 37575  
SUBJECT TO APPROVAL  
ENGINEERING  
RETURN TO  
1225  
INSTALL AE1S-1032-130 INSERT  
D3672-3 WASHER  
AN960C10L  
DRILL Ø0.391  
INSTALL AL54-428-165 INSERT  
D3672-3 WASHER  
AN960C416L  
AFTER FINISH  
(TYP 4 PLACES)



RELEASED  
07.11.2017

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